

Work Order ID 141021

Tuesday, February 23, 2016 8:31:43 AM

141021

Page 1

Item ID: D139-799-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Engine Wash

Start Date: 1/14/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: FEB 23 2016 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D139-799

K

MLJ

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D139-799-015
CHG005*X2*DAS
27
9-89

MAR 09 2016

*MLJ 16-02-23**(2)*

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

FEB 23 2016

DAS
6
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

*X2*DAS
27
9-89

MAR 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D139-799-015

Location: _____

PPP rev: _____

fg019

BAS
27
9-89

X2

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MAR 09 2016

MCJ

MAR 09 2016

MCJ

MAR 09 2016

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Picklist Print

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Work Order ID: 141021

Parent Item: D139-799-015

Parent Item Name: Engine Wash

141021

D139-799-015

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B 11.07.04 new issue DD verf:JLM IPP REV:B
AS PER ECN 11-598 11-06-05 JLM VEF BY:DD IPP Rev:C 11.09.27
PER CHG003 DD verf:EC IPP Rev:D 13.09.24 PER
CHG005/ECN13-579 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4121-1 *D4121-1* Hose Assy		Manufactured	No			110	Each	8.0000	** 2	4		DAS 6 9-89	DAS 28 9-89

Location	Loc Qty	Loc Code
FG	3	
114101	1	
132053	2	
ST213	5	
137293	1	
141290	4	

D4121-3 *D4121-3* Hose Assy		Manufactured	No			110	Each	7.0000	** 3	2		DAS 6 9-89	DAS 28 9-89
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Location	Loc Qty	Loc Code
FG	1	
91535	1	
ST213	5	
137268	1	
140524	4	
ST214	1	
129024	1	

FEB 24 2016

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
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Work Order ID: 141021

Parent Item: D139-799-015

Parent Item Name: Engine Wash

141021

D139-799-015

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 2.00

Required Qty: 2.00

D4121-5 Manufactured No

110 Each

7.0000

2

D4121-5

Hose Assy

**

Location

Loc Qty

Loc Code

ST213

7

137227

3

140525

4

68-6
9
SVQ
DAS
28
9-89

D4131-041 Manufactured No

110 Each

3.0000

2

D4131-041

Manifold Assembly

**

Location

Loc Qty

Loc Code

ST085

3

136395

3

68-6
9
SVQ
DAS
28
9-89

D4131-043 Manufactured No

110 Each

5.0000

2

D4131-043

Doubler Assembly

**

Location

Loc Qty

Loc Code

ST085

5

138225

5

68-6
9
SVQ
DAS
28
9-89

D4146-1 Manufactured No

110 Each

3.0000

4

D4146-1

Fitting

**

Location

Loc Qty

Loc Code

ST085

3

137090

3

68-6
9
SVQ
DAS
28
9-89

FEB 23 2016

Tuesday, February 23, 2016 8:31:50 AM

Shop Packet Print

Page 2

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Work Order ID: 141021

Parent Item: D139-799-015

Parent Item Name: Engine Wash

141021

D139-799-015

Start Date: 1/14/2016

Start Qty: 2.00

Required Date: 1/26/2016

Required Qty: 2.00

D4182-1

Manufactured No

110

Each

24.0000

2 4

D4182-1

Fitting, Quick Disconnect

DAS
27
9-89

Location

Loc Qty

Loc Code

ST089

24

138966

4

140529

5

141325

4

141755

11

DAS
28
9-89

D4384-1

Manufactured No

110

Each

9.0000

2

D4384-1

Placard

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

80679

5

ST095

4

140782

4

110

Each

37.0000

8

AN526-1032R16

Purchased

No

AN526-1032R16

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

ST326

37

m133234

37

DAS
6
9-89

DAS
28
9-89

DAS
6
9-89

FEB 23 2016

DAS
28
9-89

Tuesday, February 23, 2016 8:31:51 AM

Shop Packet Print

p 3.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Parent Item Name: Engine Wash

141021
D139-799-015

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 2.00

Required Qty: 2.00

AN832-6J

Purchased

No

110

Each

27.0000

2

4

AN832-6.1

Union

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK06

18

m133234

8

m134134

10

ST324

8

~~m134257~~

8

ST332

1

m133031

1

AN924-6J

Purchased

No

110

Each

27.0000

4

8

AN924-6.1

NUT

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

4

123245

2

m132256

2

ST322

23

m133686

13

~~m134257~~

10

MS21919-WDG9

Purchased

No

Each

258.0000

20

40

MS21919-WDG9

Clamp

**

FEB 23 2016

Location

Loc Qty

Loc Code

over008

200

m134142

100

m134294

100

ST293

58

m133234

58

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Misidentified ☐	Past Due ☐																																																																

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Parent Item: D139-799-015

Parent Item Name: Engine Wash

141021

D139-799-015

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0932R

Purchased

No

110

Each

115.0000

4

8

NAS1149C0932R

WASHER

**

Location

Loc Qty

Loc Code

ST265

115

m131026

15

m133992

100

DAS
27
9-89

DAS
6
9-89

DAS
28
9-89

FEB 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
		OTHER : ☐																							

5.0 PARTS LIST

Qty -011	Qty -012	Qty -015	Qty -017	Qty -019	Qty -112	Qty -211	Qty -212	Qty -213	Part Number	Description
X									D139-799-011	MAINTENANCE STEP KIT, LH
	X								D139-799-012	MAINTENANCE STEP KIT, RH
		X							D139-799-015	ENGINE WASH KIT
			X						D139-799-017	CARGO FLOOR PROTECTOR KIT
				X					D139-799-019	CABIN FLOOR PROTECTOR KIT
					X				D139-799-112	MAINTENANCE STEP WITH GRAB BAR KIT, RH
						X			D139-799-211	QUICK RELEASE MAINTENANCE STEP KIT, LH
							X		D139-799-212	QUICK RELEASE MAINTENANCE STEP KIT, RH
								X	D139-799-213	QUICK RELEASE MAINTENANCE STEP PROVISIONS KIT
			2						D3580-1	JOGGLE BRACKET
			2	8					D3628-1	CUPPED WASHER
1									D4092-041	MAINTENANCE STEP ASSEMBLY
	1								D4092-042	MAINTENANCE STEP ASSEMBLY
		2							D4121-1	HOSE-ASSEMBLY
		1							D4121-3	HOSE ASSEMBLY
		1							D4121-5	HOSE ASSEMBLY
				1					D4130-1	FWD CABIN FLOOR PROTECTOR
				1					D4130-3	AFT CABIN FLOOR PROTECTOR
			1						D4130-5	FWD CARGO FLOOR PROTECTOR
			1						D4130-7	CENTER CARGO FLOOR PROTECTOR
			1						D4130-9	AFT CARGO FLOOR PROTECTOR
		1							D4131-041	MANIFOLD ASSEMBLY
		1							D4131-043	DOUBLER ASSEMBLY
		2							D4146-1	FITTING
			1						D4153-1	JOGGLE BRACKET
			1						D4153-3	JOGGLE BRACKET
				4					D4153-5	CLAMP PLATE
			2						D4166-1	PLACARD, MAX LOAD
		2							D4182-1	FITTING, QUICK DISCONNECT
		1							D4384-1	PLACARD
					1				D4526-042	MAINTENANCE STEP ASSEMBLY, RH
						1			D5238-041	MAINTENANCE STEP ASSEMBLY
							1		D5238-042	MAINTENANCE STEP ASSEMBLY
						1	1	1	D5238-043	LOWER BRACKET, AFT
						1	1	1	D5238-045	LOWER BRACKET, FWD
						1	1	1	D5245-1	MOUNTING BOLT
2	2				2	2	2	2	AN6H12A	BOLT
2	2				2	1	1	1	AN6H13A	BOLT
		4							AN526-1032R16	SCREW
		2							AN832-6J	UNION
		4							AN924-6J	NUT
		20							MS21919WDG09	CLAMP
6	6				6	5	5	5	NAS1149D0663J	WASHER (or AN960JD616)
		4							NAS1149C0932R	WASHER (or AN960C916L)